SK D8-G

gas shielded metal cored wire

Classifications

DIN 8555

MF 3-GF-40-T

Characteristics

Special alloy designed for the repair and the hard surfacing of tools working at low and high temperatures. The resistance to thermal shocks, mechanical stresses and adhesive wear is maintained up to 500-550 °C.

Microstructure:	Martensite
Machinability:	Good with metallic carbide tipped tools
Oxy-acetylene cutting:	Can be flame cut
Deposit thickness:	Depends upon application and procedure used
Shielding gas:	Argon 98% + Oxygen 2%

Field of use

Cold shear blades, hot punches, hot extrusion dies, mill guides, moulds, camshafts.

Typical analysis in %

C	Mn	Si	Cr	W	V	Fe
0,1	1,1	0,4	2,4	3,8	0,6	balance

Typical mechanical properties

Hardness as welded: 38 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	200-300	25-31	20 max.	12-15
1,6	250-450	25-31	20 max.	15-18